

Date: Friday, 11/18/2005 2:06:11 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKID LH 206L1,L3,L4&407
Job Number	: 24795		
Estimate Number	: 10307		
P.O. Number	: N/A	Part Number	: D206642511
This Issue	: 11/18/2005	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: N/A
Previous Run	: 24794	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 12/20/2005
Checked & Approved By	: SEE COMMENT BELOW	Qty:	1
Comment	: Est Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-511CHG002

DH-06/01/17 (1)

2.0	24795A	FLOAT SKIDTUBE ASSEMBLY
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Comment: Sub-Component FLOAT SKIDTUBE ASSEMBLY

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D206642541	Float Skidtube Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Float Skidtube Assembly

From FP:

Qty 1 D206-642-541 Batch: B24795

5.0	D206648013	GHW Kit
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D206-648-013 GHW Kit B24327

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Friday, 11/18/2005 2:06:11 PM
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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 24795

Part Number: D206642511

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2652

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 D2652

Bushing

B21091

7.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

10 D2712

Set Screw

B24216

8.0

D29321

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2932-1

Saddle

B15673 B21204

9.0

D29331

206 Saddle Left



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2933-1

Saddle

B15674 B21106

10.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2934

Saddle Spacer

B21108

11.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2935

Saddle Spacer

B21109

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH 206L1,L3,L4&407

Job Number: 24795

Part Number: D206642511

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	D29381	206 Saddle Left side
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2938-1	Saddle	B21112 B21715

13.0	D29391	206 Saddle Left side
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2939-1	Saddle	B21112

14.0	D33963	Inventory
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3396-3	Spacer	B24583

15.0	D3407043	Tow Ring
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3407-043	Tow Ring	B24584

16.0	D34561	Inventory
------	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3456-1	Washer	B24174

17.0	D34571	Inventory
------	--------	-----------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3457-1	Washer	B24585

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Job Number: 24795

Part Number: D206642511

Job Number:



Seq. #:	Machine Or Operation:	Description :
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18.0	AN3C35A	Inventory
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	AN3C35A	Bolt	M18918

19.0	AN3C36A	BOLT
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Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
9	AN3C36A	Bolt	M18918

20.0	AN3C41A	Inventory
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	AN3C41A	Bolt	M18918

21.0	AN4C6A	Bolt
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
12	AN4C6A	Bolt	M17831

22.0	AN5C11A	Inventory
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	AN5C11A	Bolt	M18918

23.0	AN5C12A	Inventory
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN5C12A	Bolt	M18918

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: FLOAT SKID LH 206L1,L3,L4&407

Job Number: 24795

Part Number: D206642511

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN5C13A

Inventory



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C13A

Bolt

M18918

25.0

AN5C15A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C15A

Bolt

M18777

26.0

AN5C32A

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C32A

Bolt

M18918

27.0

AN5C34A

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C34A

Bolt

M18918

28.0

AN5C35A

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C35A

Bolt

M18918

29.0

AN960C10L

Inventory



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C10L

Washer

M18822

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH 206L1,L3,L4&407

Job Number: 24795

Part Number: D206642511

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

AN960C416L

Inventory



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

24 AN960C416L Washer M18918

31.0

AN960C516L

Inventory



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN960C516L Washer M18918

32.0

MS210433

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

20 MS21043-3 Nut M17239

33.0

MS210434

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Pick:

Qty Part Number Description Batch

13 MS21043-4 Nut M18535

34.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS21043-5Nut M17997

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH 206L1,L3,L4&407

Job Number: 24795

Part Number: D206642511

Job Number:



Seq. #:	Machine Or Operation:	Description :
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35.0	NAS1515H3L	WASHER
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Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
24 NAS1515H3L	Washer	M17450

36.0	NAS1515H4L	Inventory
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Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
24 NAS1515H4L	Washer	M18809

37.0	NAS1515H5	Washer
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
16 NAS1515H5	Washer	M18143

38.0	NAS1515H5L	WASHER
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
8 NAS1515H5L	Washer	M17659

39.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

C206642511 (1)

40.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-511

Location: _____

REV A 10/1/17 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 2:06:12 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH 206L1,L3,L4&407

Job Number: 24795

Part Number: D206642511

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SUR 06/01/18 (1) SP 06/01/18 (1)

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No	:	0024795	Department Code:	
Project Name	:	D206-642-511	Burden Flags	: NNNNNNNN
Project For	:	WK550	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	*D206-642-511	Invoice Number	:
Description	:	Float Skidtube LH	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	1	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	11-17-05		
Est Finish Date	:	12-20-05	Est Margin	: 0.000%
Act Finish Date	:		Actual Margin	: 0.000%
Drawings Req'd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====					
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====					
Burden	: 0.00	0.00	0.00		
=====					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

Date: Friday, 11/18/2005 2:06:48 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOAT SKIDTUBE ASSEMBLY
Job Number : 24795A	
Estimate Number : 10309	
P.O. Number :	Part Number : D206642541
This Issue : 11/18/2005 S.O. No. :	Drawing Number : D3274 REV C
Prsht Rev. : NC	Project Number :
First Issue : / / Type : LANDING GEAR	Drawing Revision : C
Previous Run : 24794A	Material :
Written By :	Due Date : 12/20/2005 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Est Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26001240	Extrusion Round 3" 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-1-240 3" OD Tube

B10427 DP05-11-23

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Cut D2600-1 to 190.00" in length as per Dwg D3274 and Deburr ends

DP05-11-23

2-Drill #40 Aft cap pilot hole using DT8025

DP05-11-23

3-Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

DP05-11-23

4-Remove inner indexing ridge on aft end of skidtube as per Dwg D3274

DP05-11-24

5-Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP05-11-24

6-Open Ø0.313" crossbolt spacer holes using DT8743 as per Dwg D3274

pmc 05-11-28

7-Open Ø0.375" crossbolt spacer holes using DT8744 as per Dwg D3274

pmc 05-11-28

8-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

pmc 05-11-28

W/O:		WORK ORDER CHANGES					
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Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24795A

Part Number: D206642541

Job Number:



Seq. #: Machine Or Operation: Description :

3.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine tube as per QSI 005 4.1 *A.M 05-11-24*

4.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 06-01-03

5.0 D3282041 I-Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3282-041 Float Web

B24862 Pm^c 06-01-04 ①

6.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bond web in place as per Dwg D3274 & QSI 015.

A/R Sikaflex-291

m19134

Sikaflex expire date:

06-06-20

Start:

06-01-04 5:00

Finish:

06-01-05 8:00

(Adhere for 12 hours)

Pm^c 06-01-04

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-01-05 ①

8.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bend tube using program D3274 as per Dwg D3274. Install drop pins in cross bolt spacer holes to maintain web position.

DP 06-1-5 ①

2-Cut Fwd end of tube to length as per Dwg D3274

DP 06-1-5 ①

3-Remove inner indexing ridge on Fwd end of skidtube as per Dwg D3274

BE 06-01-05 ①

W/O:		WORK ORDER CHANGES					
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT, SKIDTUBE ASSEMBLY

Job Number: 24795A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description:

4-Drill pilot holes for wearplates using D3274-1T2, then open to Ø0.297" (without cutting fluid)

5-Deburr

6-C'sink cross bolt holes as per Dwg D3274

BE 06-01-05 ①

BE 06-01-05 ①

3.257" 9/1/06 06-01-05

BE 06-01-05 ①

9.0

D32851

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3285-1 Fwd Cap

B 217441 BE 06-01-06 ①

10.0

D2649

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D2649 Crossbolt spacer

B 24200 BE 06-01-06 ①

11.0

D32751

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D3275-1 Crossbolt spacer

B 24861 BE 06-01-06 ①

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld Fwd Cap as per Dwg D3274 and QSI 004. Use aluminum rod.

A/R Aluminum Rod

M15855/M18901 BE 06-01-06 ①

2-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod

M15855 BE 06-01-06

3-Grind welds flush to Fwd cap on top surface only.

BE 06-01-09

4-Grind cross bolt welds flush as per Dwg D3274. Masking Tape access to inside of the skidtube

BE 06-01-09

5-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid jig and deburr

BE 06-01-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 2:06:48 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24795A

Part Number: D206642541

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

13.0	QC5/9	WELD INSPECTION
------	-------	-----------------



Comment: Inspect weld and Counterbore. Inspect for foreign objects as per QSI 024

APD 06-01-10

PTD

14.0	POWDER COATING	POWDER COATING
------	----------------	----------------



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06-01-13

15.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MA 06 01 13

16.0	D3415041	Nut Plate
------	----------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3415-041	Nut Plate	24574

FC 06 01 13

17.0	CCR264SS33	Cherry Rivet
------	------------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	CCR264SS3-3	Rivet	m18548

FC 06 01 13

18.0	CR3212403	Cherry Rivet
------	-----------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	CR3212-4-03	Rivet	m15918

FC 06 01 13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06-01-10	8	C'sink detail not shown or described on Dwg D3274 (Rev. C) Add this detail too Dwg, also ensure hole size is correct. Ø.257 for permanent change <i>[Signature]</i>				<i>[Signature]</i>	<i>[Signature]</i> 06-01-10	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 06/01/10
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 2:06:48 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24795A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D26483

Wearpad



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 D2648-3 Wearpad 23978C

FC 06 01 13

20.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-15 Wearshoe D21712

FC 06 01 13

21.0

D265623

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-23 Wearshoe B22085

FC 06 01 13

22.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-35 Wearshoe 24148

FC 06 01 13

23.0

D32871

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3287-1 Wearshoe B21719

FC 06 01 13

24.0

D34291

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3429-1 Wearpad B24417

FC 06 01 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

- QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 2:06:48 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24795A

Part Number: D206642541

Job Number:



Seq. #:	Machine Or Operation:	Description :
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25.0	AN960C10L	Inventory
------	-----------	-----------



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
78	AN960C10L	Washer	m18822

FC 06 0113

26.0	MS27039C108	SCREW
------	-------------	-------



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
78	MS27039C1-08Screw		m17460

FC 06 0113

27.0	NAS1330C3KB116	Insert
------	----------------	--------



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
78	NAS1330C3KB116 Inserts		m19014

FC 06 0113

28.0	NAS1515H3L	WASHER
------	------------	--------



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
78	NAS1515H3L Washer		m17450

FC 06 0113

29.0	D34131	RING
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3413-1	Ring	B24222

FC 06 0113

30.0	AN4C5A	BOLT
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN4C5A	Bolt	m18918

FC 06 0113

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 2:06:48 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24795A

Part Number: D206642541

Job Number:



Seq. #:	Machine Or Operation:	Description :
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31.0	AN960C416L	Inventory
------	------------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN960C416L	Washer	m18822

FC 06 01 B

32.0	NAS1515H4L	Inventory
------	------------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	NAS1515H4L	Washer	m18918

FC 06 01 B

33.0	D2646	Aft Cap
------	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	23370

FC 06 01 B

34.0	AN960C10L	Inventory
------	-----------	-----------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN960C10L	Washer	m18822

FC 06 01 B

35.0	MS27039C108	SCREW
------	-------------	-------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
12	MS27039C1-08Screw		m17460

FC 06 01 B

36.0	NAS1515H3L	WASHER
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	NAS1515H3L	Washer	m17450

FC 06 01 B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 2:06:49 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24795A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

A/RN/ALPS-3 m17395

FC 06 01 15

2-Install inserts & wearpads as per Dwg D3274. Use a drop of Sikaflex inside insert holes and a layer of sikaflex between wearplates and skidtube.

A/R Sikaflex-291 m19134

Sikaflex expire date: 06 20 06

FC 06 01 15

3-Install ring as per Dwg D3274

A/R Sikaflex-291 m19134

Sikaflex expire date: 06 20 06

FC 06 01 16

4-Inspect for foreign objects as per QSI 024

FC 06 01 16

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291 m19134

Sikaflex expire date: 06 20 06

FC 06 01 16

38.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FC 06 01 16

39.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

FC 06 01 18

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5/21

for the next one

DART AEROSPACE LTD		Work Order:	23131
Description: Float Skidtube, LH (206L/L1/L3/L4/407)		Part Number:	D206-642-511
Dwg:		Qty:	1
Page 1 of 2			

Step	Location	Procedure	By	Date	Qty																																																																																																																																												
1	DC	Issue Travelers for: D206-642-511 Skidtube D206-642-541 Skidtube Assembly Batch: <u>23131</u> <u>23131</u>	<i>KA</i>	05.09.26	1																																																																																																																																												
2	DC	Photocopy bluefile and create labels per PPP D206-642-511 CHG002 <u>W 39 KA</u>																																																																																																																																															
3	LG	Go to Traveler D206-642-541																																																																																																																																															
4	PK	Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr><td>1</td><td>D206-648-013</td><td>GHW Kit</td><td>B24327</td></tr> <tr><td>16</td><td>D2652</td><td>Bushing</td><td>B21091</td></tr> <tr><td>10</td><td>D2712</td><td>Set Screw</td><td>B24216</td></tr> <tr><td>1</td><td>D29321</td><td>Saddle</td><td>B21204</td></tr> <tr><td>1</td><td>D2933-1</td><td>Saddle</td><td>B21008</td></tr> <tr><td>2</td><td>D2934</td><td>Saddle Spacer</td><td>B21108</td></tr> <tr><td>2</td><td>D2935</td><td>Saddle Spacer</td><td>B21109</td></tr> <tr><td>1</td><td>D2938-1</td><td>Saddle</td><td>B21715</td></tr> <tr><td>1</td><td>D2939-1</td><td>Saddle</td><td>B21112</td></tr> <tr><td>2</td><td>D3396-3</td><td>Spacer</td><td>B24583</td></tr> <tr><td>1</td><td>D3407-043</td><td>Tow Ring</td><td>B24584</td></tr> <tr><td>1</td><td>D3456-1</td><td>Washer</td><td>B24174</td></tr> <tr><td>2</td><td>D3457-1</td><td>Washer</td><td>B24585</td></tr> <tr><td>3</td><td>AN3C35A</td><td>Bolt</td><td>M18918</td></tr> <tr><td>9</td><td>AN3C36A</td><td>Bolt</td><td>M18918</td></tr> <tr><td>8</td><td>AN3C41A</td><td>Bolt</td><td>M18918</td></tr> <tr><td>12</td><td>AN4C6A</td><td>Bolt</td><td>M17831</td></tr> <tr><td>8</td><td>AN5C11A</td><td>Bolt</td><td>M18918</td></tr> <tr><td>4</td><td>AN5C12A</td><td>Bolt</td><td>M18918</td></tr> <tr><td>4</td><td>AN5C13A</td><td>Bolt</td><td>M18918</td></tr> <tr><td>1</td><td>AN5C15A</td><td>Bolt</td><td>M18778</td></tr> <tr><td>2</td><td>AN5C32A</td><td>Bolt</td><td>M18918</td></tr> <tr><td>2</td><td>AN5C34A</td><td>Bolt</td><td>M13715 M18918</td></tr> <tr><td>1</td><td>AN5C35A</td><td>Bolt</td><td>M18918</td></tr> <tr><td>24</td><td>AN960C10L</td><td>Washer</td><td>M1822</td></tr> <tr><td>24</td><td>AN960C416L</td><td>Washer</td><td>M18918</td></tr> <tr><td>8</td><td>AN960C516L</td><td>Washer</td><td>M18918</td></tr> <tr><td>20</td><td>MS21043-3</td><td>Nut</td><td>M17239</td></tr> <tr><td>13</td><td>MS21043-4</td><td>Nut</td><td>M18535</td></tr> <tr><td>4</td><td>MS21043-5</td><td>Nut</td><td>M17917</td></tr> <tr><td>24</td><td>NAS1515H3L</td><td>Washer</td><td>M17450</td></tr> <tr><td>24</td><td>NAS1515H4L</td><td>Washer</td><td>M18809</td></tr> <tr><td>16</td><td>NAS1515H5</td><td>Washer</td><td>M18143</td></tr> <tr><td>8</td><td>NAS1515H5L</td><td>Washer</td><td>M17659</td></tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D206-648-013	GHW Kit	B24327	16	D2652	Bushing	B21091	10	D2712	Set Screw	B24216	1	D29321	Saddle	B21204	1	D2933-1	Saddle	B21008	2	D2934	Saddle Spacer	B21108	2	D2935	Saddle Spacer	B21109	1	D2938-1	Saddle	B21715	1	D2939-1	Saddle	B21112	2	D3396-3	Spacer	B24583	1	D3407-043	Tow Ring	B24584	1	D3456-1	Washer	B24174	2	D3457-1	Washer	B24585	3	AN3C35A	Bolt	M18918	9	AN3C36A	Bolt	M18918	8	AN3C41A	Bolt	M18918	12	AN4C6A	Bolt	M17831	8	AN5C11A	Bolt	M18918	4	AN5C12A	Bolt	M18918	4	AN5C13A	Bolt	M18918	1	AN5C15A	Bolt	M18778	2	AN5C32A	Bolt	M18918	2	AN5C34A	Bolt	M13715 M18918	1	AN5C35A	Bolt	M18918	24	AN960C10L	Washer	M1822	24	AN960C416L	Washer	M18918	8	AN960C516L	Washer	M18918	20	MS21043-3	Nut	M17239	13	MS21043-4	Nut	M18535	4	MS21043-5	Nut	M17917	24	NAS1515H3L	Washer	M17450	24	NAS1515H4L	Washer	M18809	16	NAS1515H5	Washer	M18143	8	NAS1515H5L	Washer	M17659			
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5	PK	From FP: Qty 1 D206-642-541 Batch: _____																																																																																																																																															
6	QC4	Inspect Kit 100% for Completeness on the W/O	<i>CL</i>	05/11/10	1																																																																																																																																												
7	PK	Identify and package per PPP D206-642-511																																																																																																																																															

Let not shipped
on B23131 per
Bill -
use for 24795

RELEASED
05.09.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

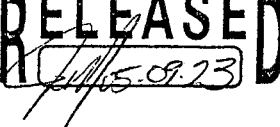
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	
Description: Float Skidtube, LH (206L/L1/L3/L4/407)		Part Number:	D206-642-511
Dwg:		Qty:	
		Page 2 of 2	

Step	Location	Procedure	By	Date	Qty
8	AC	Cost/Part: _____			
9	DC	Close work Order and Ensure Travellers Attached Inspect Level 21 Travelers: D206-642-511 D206-642-541			

Rev	Date	Change	Revised By	Approved
A	04.05.13	New Issue	KJ/DS	
B	05.09.23	Revised per D206-642 Rev. J	KJ/JLM	

RELEASED


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 21, 2005
07:37 am

Work Order No : 0023131
Project Name : D206-642-511
Project For : WK521
Work Order Type : Main
Main WO Number :
House Part Number : *D206-642-511
Description : Float Skidtube LH
Manufactured : Yes
Amount Req'd : 1
Amount Done : 0
Start Date : 04-29-05
Est Finish Date : 05-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00